


Work Order ID ~~76167~~***76167***

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Monday, November 07, 2011 12:58:27 PM

Item ID: D3276-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Baffle Assembly LH
Start Date: 11/7/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/16/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan:  Date: 11/11-07 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3276	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3276 Dwg Rev: B Prog Rev: B 2-
Debur if necessaryB111-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B111-11-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Selulu

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo 1-Deburr2-Roll as per Dwg D3276	0.00 0.00		SO 11/12/23		(5)			
140 *140* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3276	0.00 0.00		SO 11/12/23		(5)			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SO 11/12/23		(45)			wej

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				5			
Hand Finishing									

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:30								
	FINISH TIME: 2:00								
	OVEN TEMPERATURE:								

W11A480 3200F

180	QC3- Inspect Part Finish	0.00							
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180									
QC	Memo	0.00				5			

Quality Control

SX M-11/12/28

5 BR 11-12-28.

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab	Small Fab	0.00							
Small Fab	Memo Assemble as per Dwg D3276	0.00							
200 *200* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
210 *210* Packaging	Identify as per dwg & Stock Location: <u>175</u>	0.00							
Packaging	Memo	0.00							

Handwritten notes and stamps:
- Large signature: *SP 11/12/29* with a circled 5.
- Stamp: *8 11/12/29*
- Stamp: *11/12/29* with a circled 5 and a signature.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

CK 12/01/02.

H11-12-30
⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 76167

76167

Parent Item: D3276-041

D3276-041

Parent Item Name: Baffle Assembly LH

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-12-06 JLM
IPP Rev:B Now on Waterjet 06-09-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-3 *D3276-3* Decal		Manufactured	No			100	Each	13.0000	1	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST045				13					
				56593				3					
				59694				10					
D2464 *D2464* 3/4 Seal		Manufactured	No			190	f	302.1000	2.25	9			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST404				302.1					
				61878				302.1					
M6061T6S.040 *M6061T6S 040* 6061-T6 .040 Sheet		Purchased	No			190	sf	65.4100	1.0205	4.296842			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				65.41					
				113004				7.5					
				117653				57.91					

Handwritten notes and signatures:
 - Signature: *EP 11/12/29*
 - Text: *B 77063*
 - Signature: *EP 11/12/29*
 - Text: *11.25*
 - Text: *4.5*
 - Text: *FB11-11-10*
 - Text: *117653*
 - Circled number: *5*

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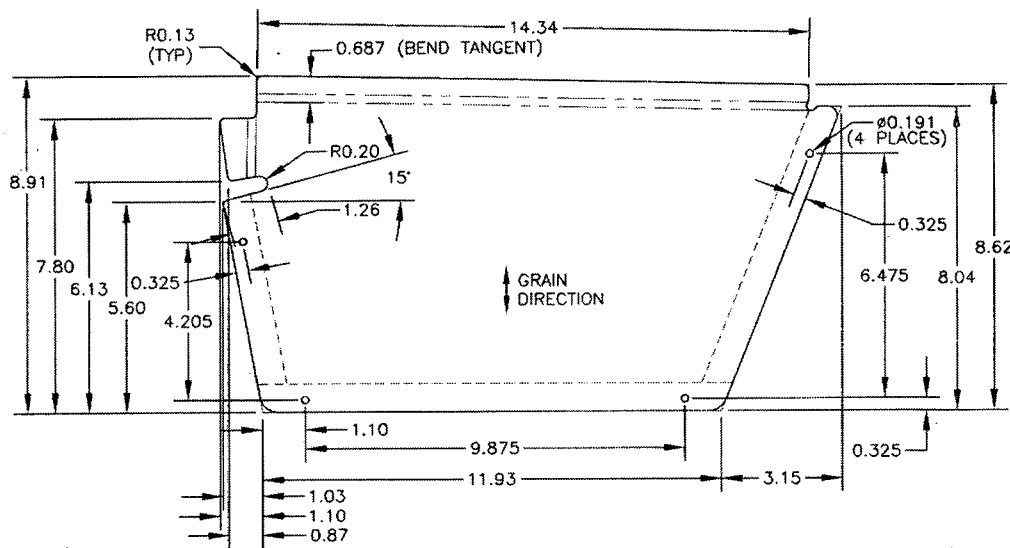
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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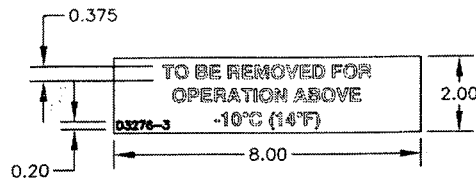
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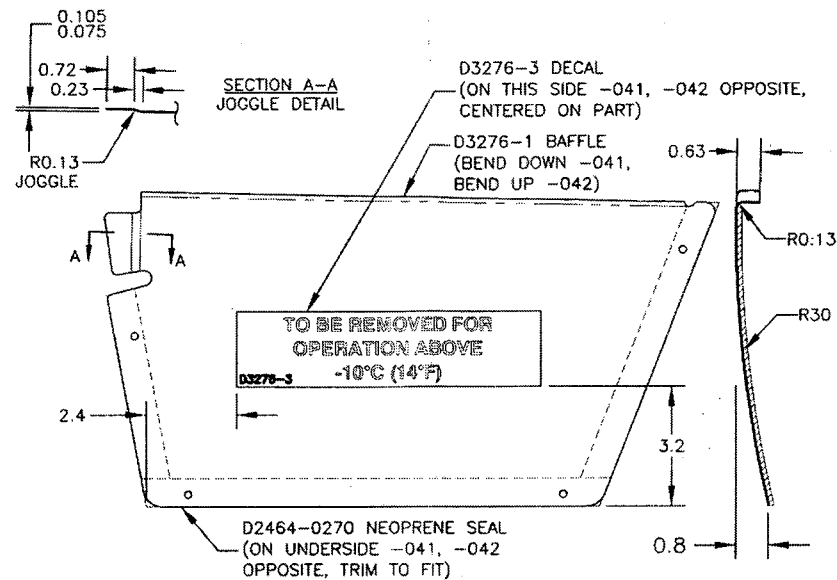
D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO A REVISION
WITHOUT NOTICE
WORK ORDER
NO. 76167

11-11-07

RELEASED
05.01.07

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		SCALE
		1:3

DART AEROSPACE LTD.
WARRICKSURY, ONTARIO, CANADA

REV. B
SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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